

Work Order ID 63732

Thursday, November 11, 2010 11:29:03 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 11/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/18/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: *10-11-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A

100 Weld per dwg A/R S.S. rod Batch: *1114649* 0.00
Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

ly 10/11/17 (1x)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

Qd 10-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 11/18/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

④
1 11-11-23

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

EP 10/11/24 (C)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/11/24

(70)

170

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

*WP 63731**EP 10/11/24* (C)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/24
MF
10-11-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, November 11, 2010 11:29:07 AM

Page 1

Work Order ID: 63732

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350



Start Date: 11/11/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	43.0000	2	2		10/11/11	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				WA				43					
					61953			20					
					63493			23					
✓ D3913-1 Rib		Manufactured	No			100	Each	6.0000	1	1		10/11/11	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				WA				6					
					59842			1					
					60674			2					
					60731			3					
✓ D3913-15 Wide Handle Plate		Manufactured	No			100	Each	6.0000	1	1		10/11/11	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				WA				6					
					60732			6					

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 63732

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/11/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-3
Rib

Manufactured No

100 Each

4.0000

1

1



10/11/17

Location

Loc Qty

Loc Code

WA

4

60323

1

60675

3

(1x)

~~D3913-7~~
Rib

Manufactured No

100 Each

8.0000

2

2



10/11/17

Location

Loc Qty

Loc Code

WA

8

59090

2

60263

6

(2x)

✓ D3913-9
Hinge Rib

Manufactured No

100 Each

4.0000

1

1



10/11/17

Location

Loc Qty

Loc Code

WA

4

60322

1

60704

3

(1x)

✓ D3916-041
Rib Assembly

Manufactured No

100 Each

4.0000

2

2



10/11/17

Location

Loc Qty

Loc Code

WA

4

60046

1

60722

3

2x

Thursday, November 11, 2010 11:29:07 AM

Shop Packet Print

Page 2

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Page 3

Work Order ID: 63732

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 35

Start Date: 11/11/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3916-5

Manufactured No

100

Each

13.0000

3

3



Light Rib



JS 10/11/17

Location

Loc Qty

Loc Code

WA

13

57023

2

60321

2

60721

9

2x
1x

✓ D4016-1

Manufactured No

100

Each

9.0000

3

3



Hinge Half, Base



JS 10/11/17

Location

Loc Qty

Loc Code

ST109

9

61062

9

(3x)

✓ D4017-7

Manufactured No

100

Each

5.0000

1



Rib



JS 10/11/17

Location

Loc Qty

Loc Code

WA

5

58929

2

61063

3

(1x)

✓ D4017-9

Manufactured No

100

Each

4.0000

2

2



Rib



JS 10/11/17

Location

Loc Qty

Loc Code

WA

4

60262

4

2x

Thursday, November 11, 2010 11:29:07 AM

Shop Packet Print

Page 3

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Page 4

Work Order ID: 63732

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/11/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4020-1

 Mesh (350 Basket Long, Base)

Manufactured No

100 Each

3.0000



1
 1
 10/11/17

Location

Loc Qty

Loc Code

WA

3

60583

3

✓ D4020-11

 End Mesh, Basket

Manufactured No

100 Each

9.0000



①
 2
 10/11/17

Location

Loc Qty

Loc Code

WA

9

59413

1

60584

2

61306

6

②

✓ D4021-1

 Handle Plate

Manufactured No

100 Each

12.0000



3
 3
 10/11/17

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

7

60677

7

③x

✓ D4034-041

 Aft Upper Rib Assembly

Manufactured No

100 Each

3.0000



1
 10/11/17

Location

Loc Qty

Loc Code

WA

3

61064

3

④x

Thursday, November 11, 2010 11:29:08 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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Page 5

Work Order ID: 63732

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, .50

Start Date: 11/11/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-043 Manufactured No 100 Each 3.0000
Fwd Upper Rib Assembly



1 1
10/11/17

AN3-10A Purchased No 150 Each 88.0000
Bolt



①
6
10/11/23
6

✗ AN960JD8 NAS1149DN832 Purchased No
Washer 40 M115996 (20)



2 2
10/11/23

D2931 Manufactured No 150 Each 770.0000
Bumper



2 2
10/11/23
2

Location Loc Qty Loc Code

WA 3
61065 3

Location Loc Qty Loc Code

ST351 88
115877 38
116075 50

Location Loc Qty Loc Code

ST347 10
105059 10

Location Loc Qty Loc Code

ST504 770
46064 770

Thursday, November 11, 2010 11:29:08 AM

Shop Packet Print

Page 5

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Thursday, November 11, 2010 11:29:08 AM

Page 6

Work Order ID: 63732

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 50

Start Date: 11/11/2010

Required Date: 11/18/2010

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

6.0000

2

2



Blanking Plate

Location

Loc Qty

Loc Code

ST111

6

60717

6

MS20600-AD4W3

Purchased

No

150

Each

1,487.000

2

2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1487

107939

754

111636

733

MS21042L3

Purchased

No

150

Each

1,789.000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

1789

114784

789

115835

1000

NAS1149F0332P

Purchased

No

150

Each

507.0000

12

12



WASHER

Location

Loc Qty

Loc Code

ST275

507

18057

507

Thursday, November 11, 2010 11:29:08 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

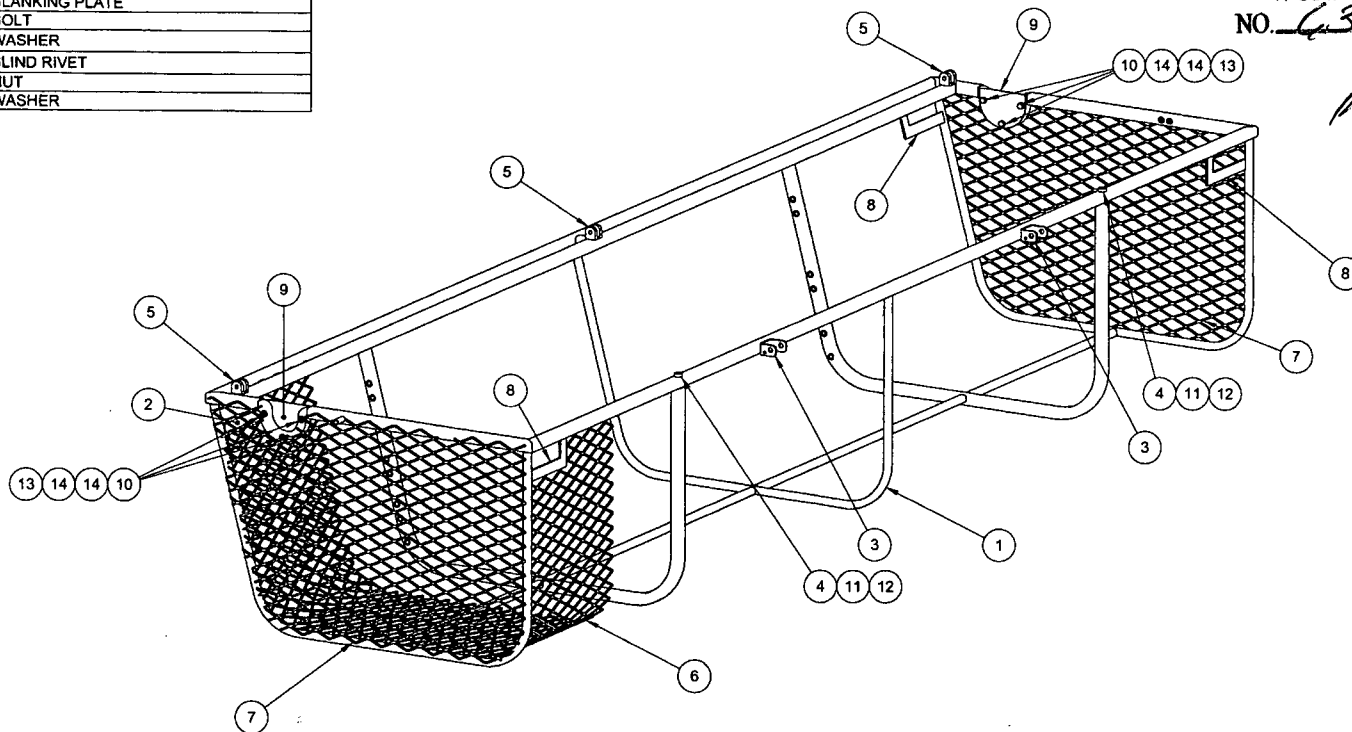
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63732

2/010-11

RELEASED
2010-03-22
WMD

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 REV. A SHEET 1 OF 6 TITLE LONG BASKET BASE ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JPH		
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	10.03.16		

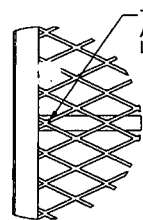
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

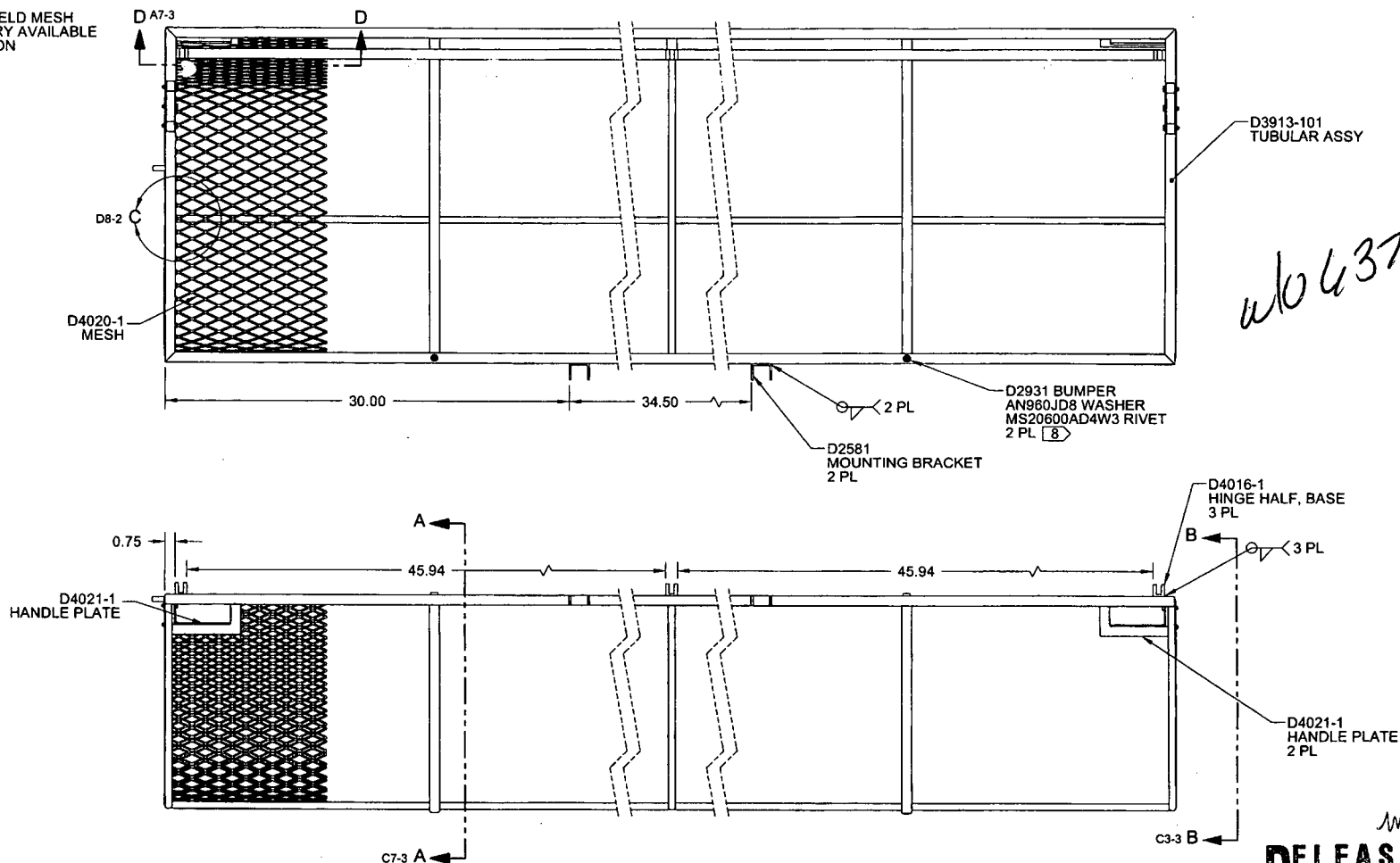
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NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-02-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	XX	D3913	SHEET 2 OF 6
APPROVED	XX	TITLE	SCALE
DE APPR.	XX	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

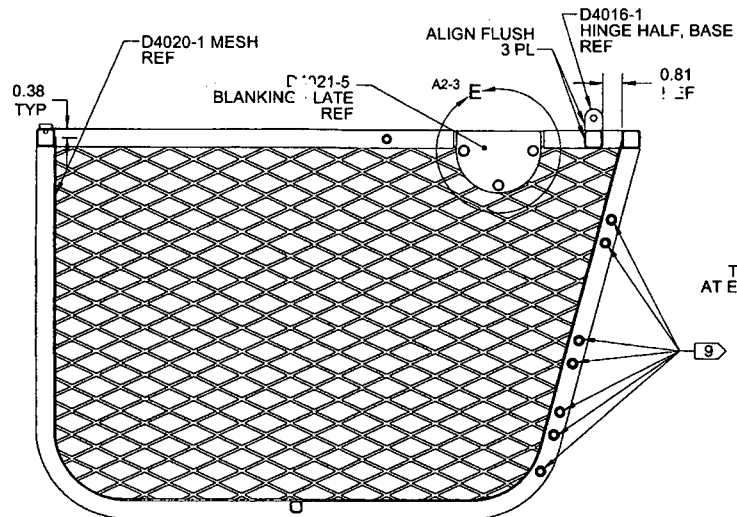
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

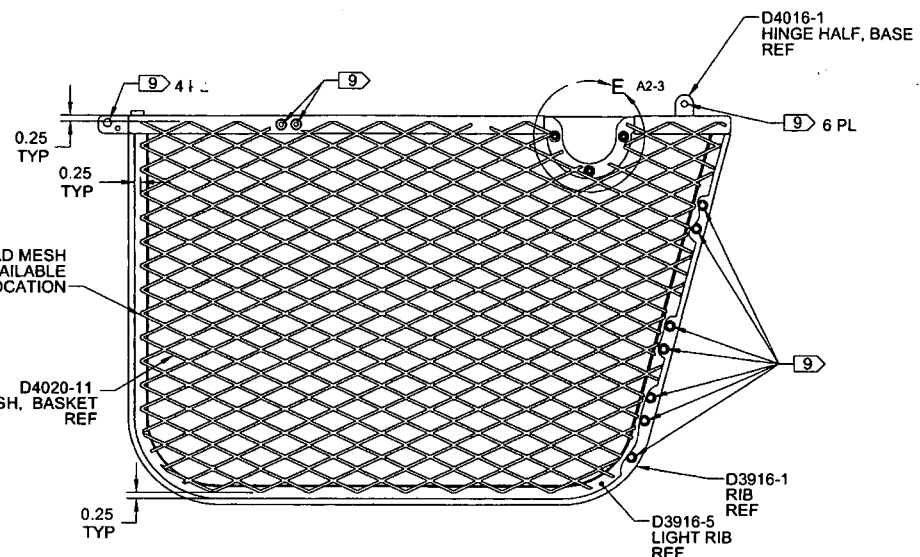
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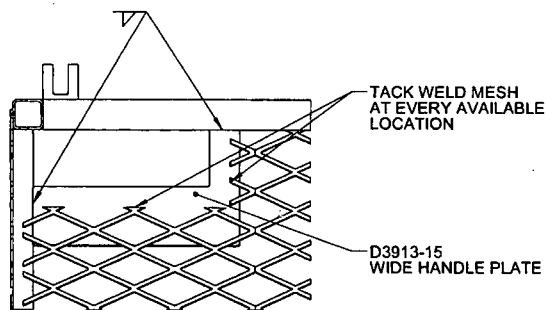
NOTE: Date & initial all entries



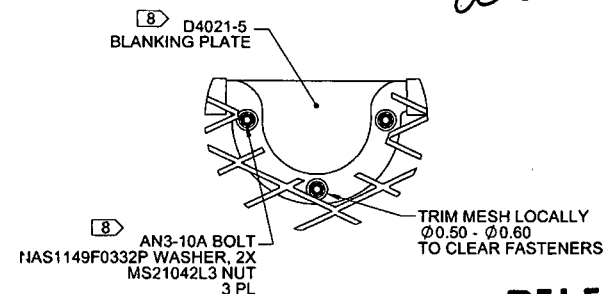
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

also 43732

RELEASED
2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

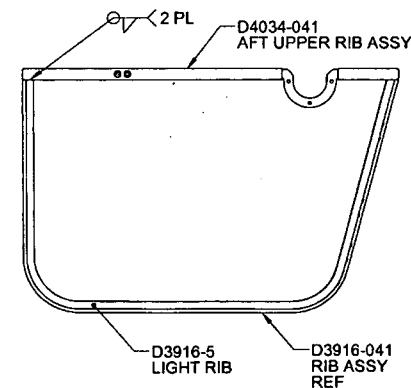
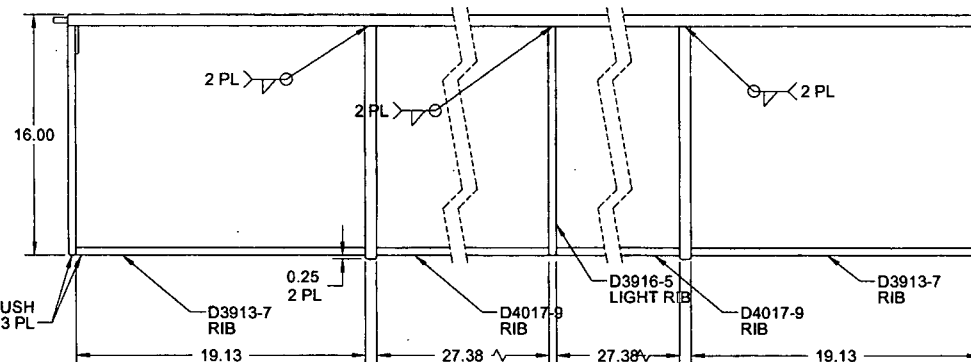
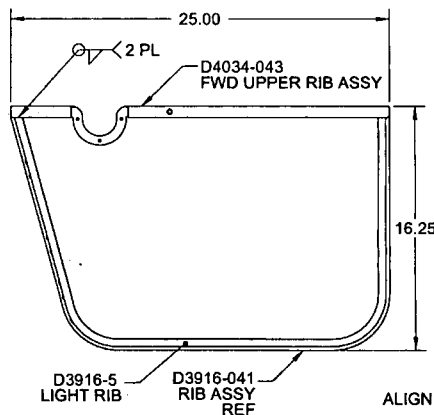
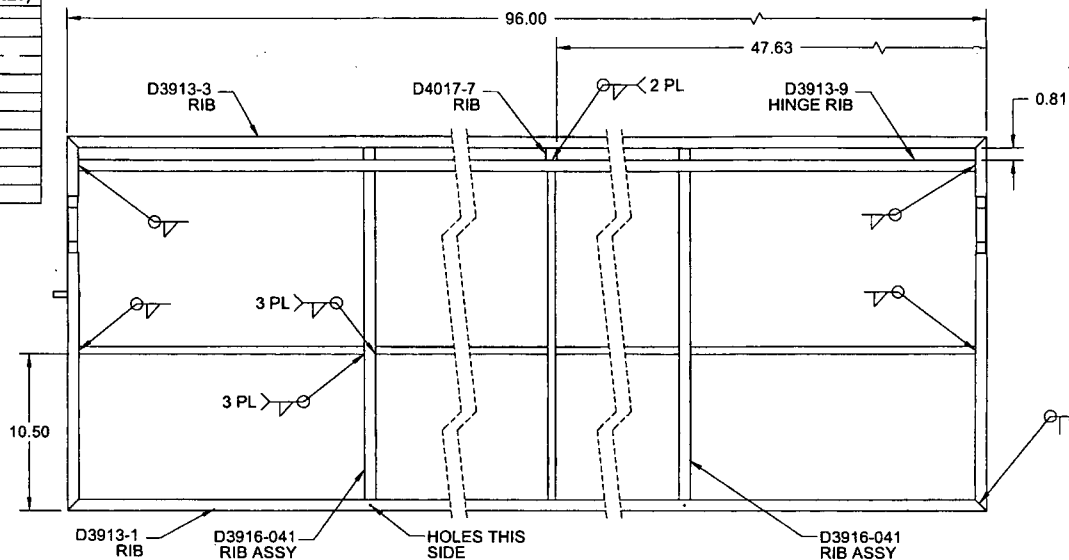
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. D3913	REV. A
MFG. APPR.			SHEET 4 OF 6
APPROVED		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

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2010-03-22

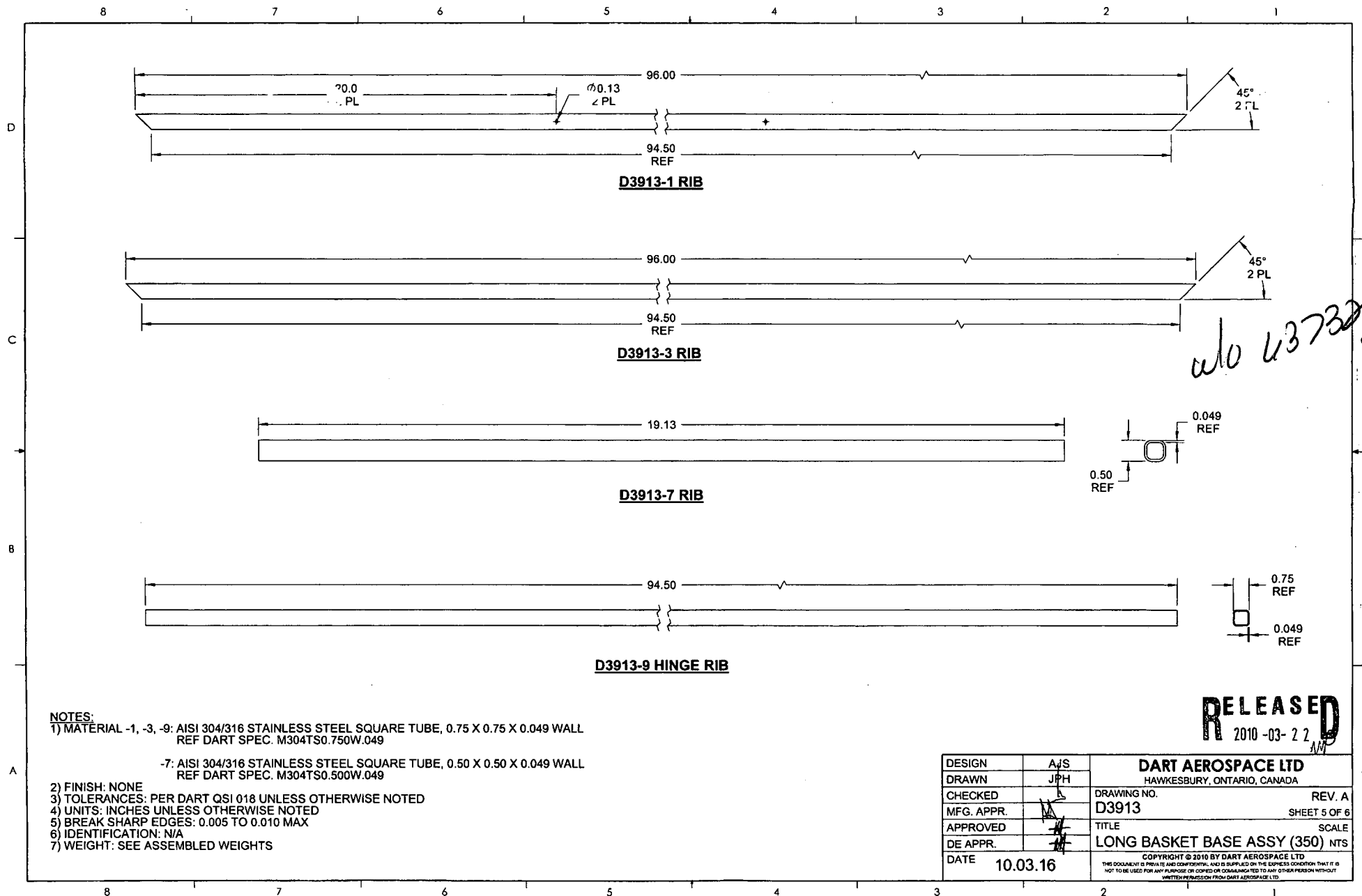
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



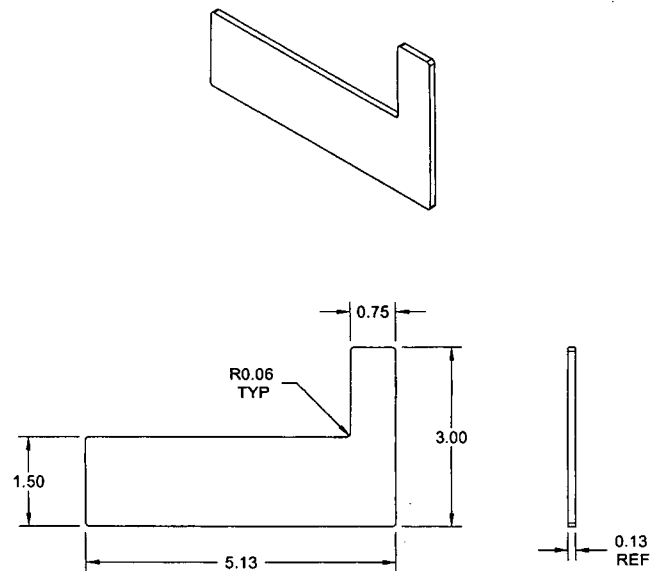
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH.
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3913	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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2010-03-22
[Signature]

also 43732

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries